

699SR Clear HS[®]



2:1 Clear Coat SCRATCH RESISTANT

Crystal clear coat with lasting gloss...



- Crystal HS clear coat with excellent high gloss and lasting protection.
- Easy application for all types of refinish use (partial-full and spot repair).
- Excellent leveling by adding thinner but also possibility of OEM surface ("orange peel" surface - without thinner).
- Fast hardening with or without baking.
- Ready for polishing, assembly or minor touch-ups 60 min after baking.

2K - Acrylic System



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699SR CLEAR COAT HS®

2:1 CLEAR COAT SCRATCH RESISTANT







V.O.C. COMPLIANT 2004/42/IIB (e) (840) 560



Substrates

Suitable Substrates: Base coats For full body repairs
2K - Acryl paints For partial or spot panel repairs
Waterbased paints


Application

Mixing ratio:	2:1 by volume with HARDENERS:	1) H 752 SLOW 2) H 753 NORMAL 3) H 754 FAST
		
Pot life @ 23°C (73°F):	>4 h with H 754 FAST >7 h with H 753 NORMAL / H 752 SLOW	
Thinner (Reducer):	740 NORMAL ACRYLIC THINNER 741 SLOW ACRYLIC THINNER	
Method of application:	High pressure	Low pressure
	 Gravity Feed	 (HVLP) Gravity feed
 Application viscosity DIN 4 @ 20°C (68°F) DIN 53211	0% Thinner (Reducer): 16 - 16.5 sec 5 - 15% Thinner (Reducer): 15 - 16 sec	
 Thinner (Reducer) @ 23°C (73°F) (material temperature)	0 - 15%	
Spray nozzle	1,3 - 1,4mm	1,2 - 1,3mm
Spray pressure	2-3 bar (29-44psi)	2 bar (29psi)
 Number of coats	2	

Recommended dry film thickness: 50-60 µm (2.00 - 2.40 mil) approx.

Drying (Hardening)

Air drying:

 @ **23°C (73°F)** with H 754 FAST with H 753 NORMAL
Dust free: **30 mins** **40 mins**
Ready for assembly: **6 - 7 hours** **7 - 8 hours**
Full hardness: **14 - 18 hours** **17 - 18 hours**

Flash off time between coats 8 - 12 min

Note

* Adding 5 - 15% thinner (reducer) helps the leveling of the clear coat. Without thinner (reducer), we achieve surface similar to original manufacturer painting (orange peel).

Temperature	Orange peel texture 1-2 parts	Leveling surface 1-2 parts	Partial Repair	Full repair
<15°C <(59°F)	H 754 15min/60°C (140°F)	H 754+max15%740 15min/60°C (140°F)	H 754+max15%740/741 15min/60°C (140°F)	H 753+max15%740 20min/60°C (140°F)
15-25°C (59-77°F)	H 754 15min/60°C (140°F)	H 754+max15%740 or H 753+max15%740 15 - 20min/60°C (140°F)	H 754+max15%741 or H 753+max15%741 15 - 20min/60°C (140°F)	H 753+max15%740/741 20min/60°C (140°F)
25-35°C (77-95°F)	H 754 15min/60°C (140°F)	H 754+max15%740/741 or H 753+max15%740/741 15 - 20min/60°C (140°F)	H 754+max15%741 or H 753+max15%741 15 - 20min/60°C (140°F)	H 753+max15%741 20min/60°C (140°F)
>35°C >(95°F)	H 754+max15%741 or H 753+max15%741 15 - 20min/60°C (140°F)	H 754+max15%741 or H 753+max15%741 15 - 20min/60°C (140°F)	H 753+max15%741 20min/60°C (140°F)	H 752+max15%741 30min/60°C (140°F)

Data

Viscosity (Clear only): 29 - 31 sec @ 20°C (68°F) DIN 4

Specific weight: 0.96g/cm³

Coverage*: With H 754 FAST / H 753 NORMAL HARDENER approx. 8,3 m²/ 60µm (2.4 mil) dry film

VOC (RFU):** 560g/L (4.7 lb/gal)

* The coverage has been calculated based on the recommended dry film thickness. The associated loss during the application has been ignored.

** RFU= Ready for use (with 10% reducer).

Storage

Guaranteed shelf-life: **BODY 699 SR HS** and relevant hardeners (H 752, H 753 and H 754) is **24 months** in unopened original tins.